

# DART SERVICE INSTRUCTION

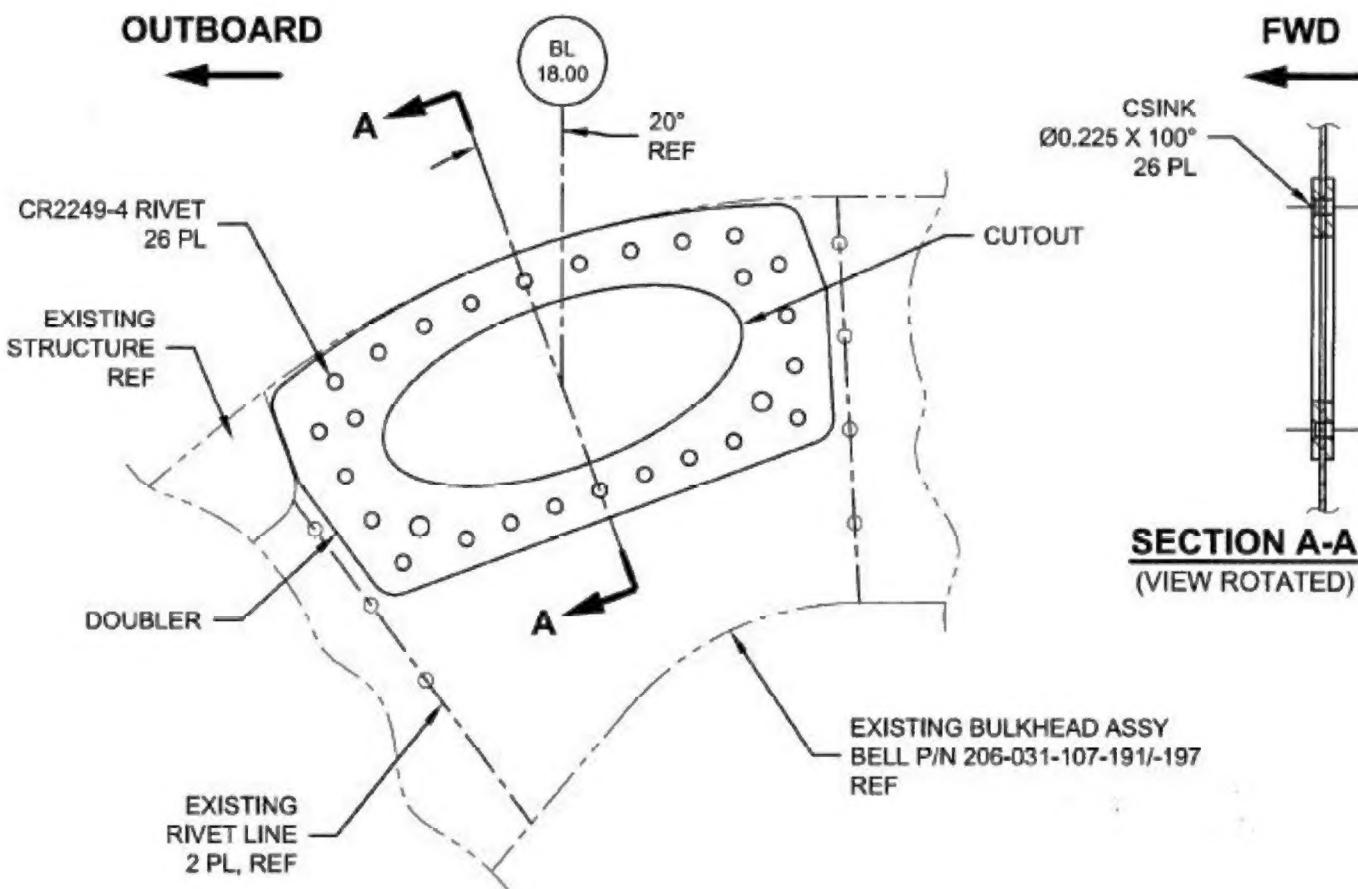
TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-746 REV. A

REF. CANADIAN STC: SH05-45

FAA STC: SH3367NM

EASA.I.M.R.S.01449

TO MAKE THE DART D206-746-011 KIT COMPATIBLE WITH SOME BELL 206A/B AIRCRAFT, IT MAY BE NECESSARY TO CUTOUT AND REINFORCE THE BULKHEAD AT STA 121.19, LBL AND RBL 18.00 PER FIGURE 1. THIS CHANGE IS REQUIRED ON AIRCRAFT S/N 3568 AND SUBSEQUENT TO ENSURE THAT THE D206-746-041 REAR PASSENGER OVERHEAD MODIFICATION KIT CAN BE INSTALLED PER IIN-D206-746.



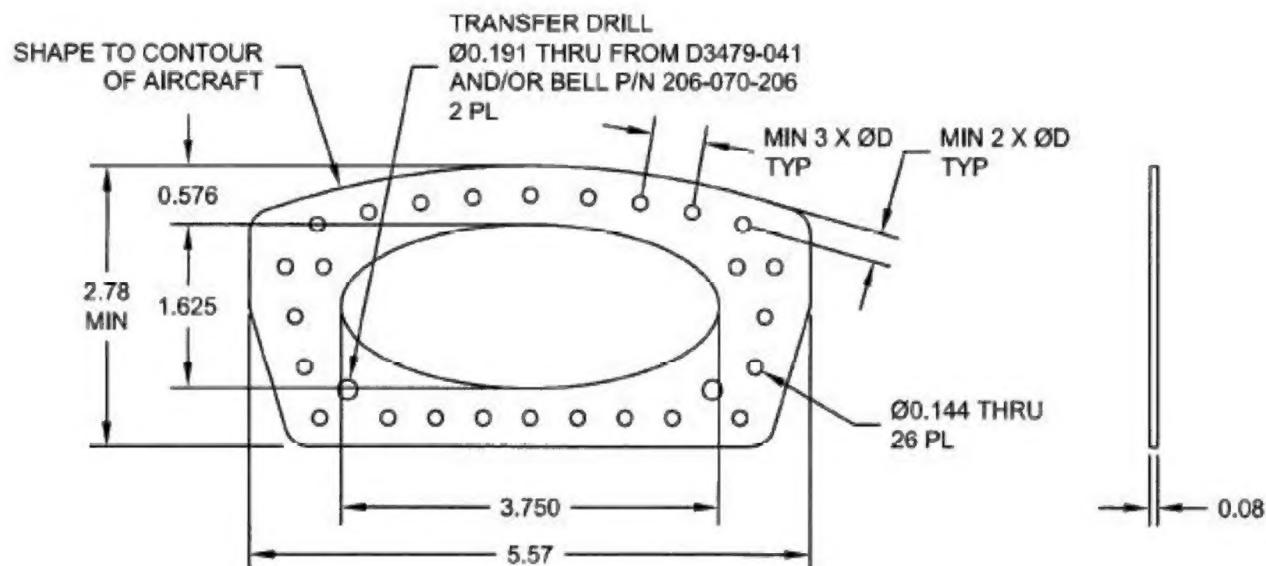
**FIGURE 1 - VIEW LOOKING AFT**  
(RH SHOWN, LH OPPOSITE)

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
<b>APPROVED</b>	
BY:	D. SHEPHERD (DE # 02)
DATE:	08.10.30
CERT. NO.:	SH05-45
ISSUE NO.:	1

A	NEW ISSUE	MB	08.10.30
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	DSI 9426	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BULKHEAD MOD	NTS
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## PROCEDURE

- 1) MAKE DOUBLERS PER FIGURE 2 OF THESE INSTRUCTIONS. COUNTERSINK Ø0.144" HOLES ON ONE DOUBLER ONLY WHICH WILL BE INSTALLED ON THE FORWARD FACE OF THE BULKHEAD PER FIGURE 1.
- 2) LOCATE DOUBLERS PER FIGURE 1 OF THESE INSTRUCTIONS.
- 3) TRANSFER ELLIPTICAL CUTOUT, Ø0.144" RIVET HOLES AND Ø0.191" FASTENER HOLES FROM DOUBLER TO THE BULKHEAD. DEBURR.
- 4) TOUCH UP AFFECTED AREAS ON BULKHEAD IN ACCORDANCE WITH AIRCRAFT MAINTENANCE MANUAL.
- 5) INSTALL THE DOUBLERS AS SHOWN IN FIGURE 1 OF THESE INSTRUCTIONS. APPLY A LAYER OF PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN DOUBLERS AND AIRCRAFT SKIN.
- 6) INSTALL DUCT ASSY BELL P/N 206-070-204 AND FLANGE ASSY BELL P/N 206-070-206 IN ACCORDANCE WITH AIRCRAFT MAINTENANCE MANUAL.
- 7) COMPLETE INSTALLATION OF D206-746-041 REAR PASSENGER OVERHEAD MODIFICATION KIT PER INN-D206-742 REV. A AND INSTALLATION DRAWING D206-746 REV. A.



## FIGURE 2 NOTES:

- 1) MATERIAL: 2024-T3 X 0.080" THICK ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037
- 2) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 3) FINISH: APPLY CHEMICAL FILM COAT OF ALODINE 1200/1201 PER MIL-C-5541.  
APPLY ONE COAT OF MIL-P-85582/MIL-P-23377 PRIMER AND AT THE INSTALLER'S DISCRETION 2-3 COATS OF MIL-C-83285 POLYURETHANE PAINT TO MATCH FINISH AND COLOR OF AIRCRAFT.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED

## FIGURE 2 - DOUBLER DETAIL

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
<b>APPROVED</b>	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
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MFG. APPR.	N/A	DSI 9426	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	
DE APPR.	<i>[Signature]</i>	SCALE	
DATE	08.10.30	NTS	

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